

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016619**Date Inspected:** 16-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD****Segment # 9CW ~ 9DW****Base Metal Repair**

This QA inspector observed, ZPMC qualified welding personnel identified as 202316 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9C-002; The Critical Welding Repair Report (CWRR) was B-CWR1728. ZPMC CWI is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair-1.

**Segment # 9DW ~ 9EW**

This QA inspector observed, ZPMC qualified welding personnel identified as 068764 & 067942 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG055A-021 & SEG057A-014; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached below Photo.

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### Segment # 9EE

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP713-001-013; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1

### Segment # 10AW ~ 10BW

This QA inspector observed, ZPMC qualified welding personnel identified as 067876 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW10-003; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223(2)1T-1. See the attached below photo.

### Segment # 9EW

This QA inspector observed, ZPMC qualified welding personnel identified as 037723 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9K-009; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-F.

### Segment # 9EE ~ 10AE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on longitudinal Diaphragm at the Bottom plate in OBG segment 9EE at panel point 85. ZPMC CWI is identified as Mr. An Qing Xiang the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9062.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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